

Work Order ID 67644

Tuesday, March 29, 2011 8:14:50 AM

Page 1

Item ID: D2066

Accept

Setup Start

Revision ID:

Stop

Item Name: Arm

Start Date: 3/29/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan: *MF* Date: *11-03-29*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2066

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Punch 1/2" OD x .049" Wall 304/316 SS Seamless Tube
(Ref QSI 017 4.1.1.2) as per Dwg D2066 (per D2727)
Use punch Jig DT8012

2-Slide on parts per Dwg and W/O for D2676-043

3-Punch other end to length (28.62") as per Dwg D2066

4-Bend per Dwg D2066

5-Drill

SIS 9034

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

6X

M-L 11/04/08
M-L 11/03/30

8/10/09

K6

W/O:		WORK ORDER CHANGES					
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Identify as per dwg & Stock Location: 227

0.00



Packaging

Memo

0.00

Packaging

11/4/12 SP (60)

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/14 J

R11-04-13 (6)

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Picklist Print

Tuesday, March 29, 2011 8:14:47 AM

Page 1

Work Order ID: 67644

Parent Item: D2066

Parent Item Name: Arm



Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP D 02.03.18 Added pick list NG
IPP E 07.10.03 removed p/c EC verified by: DD
IPP Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10 	NAS1149D0363J	Purchased	No			100	Each	0.0000	4	24			
Washer D2052 		Manufactured	No			100	Each	11.0000	2	12			
Mounting Bracket													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST005		11							
				59809 ✓		11							
D2054 		Manufactured	No			100	Each	22.0000	2	12			
Bushing													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		22							
				61834 ✓		22							
D2055 		Manufactured	No			100	Each	9.0000	1	6			
Clamp													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		9							
				58393 ✓		9							

M116583



24x m-l 11/03/29 *



67743

m-l 11/03/29

1X m-l 11/04/08 *

11X



m-l 11/03/29

12x



m-l 11/03/29

6x

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Parent Item: D2066

Parent Item Name: Arm

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 6.00

Required Qty: 6.00

D2056

Manufactured No

100

Each

12.0000

1

6



Bell Crank



m-l 11/03/29

Location

Loc Qty

Loc Code

GA

12

45542 ✓

2

66183 ✓

10

M304TR0.500W.049

Purchased

No

120

f

226.3300

2.386

15.06947



304 RD Tube .500 x .049W

m-l 11/03/29

Location

Loc Qty

Loc Code

MAT017

226.33

111814 ✓

4.33

115010 ✓

222

MS21042L3

Purchased

No

100

Each

2,189.000

2

12



Nut

m-l 11/03/29

Location

Loc Qty

Loc Code

ST300

2189

116391 ✓

589

116540

800

116549

800

MS27039-1-18

Purchased

No

100

Each

114.0000

2

12



Screw

m-l 11/03/29

Location

Loc Qty

Loc Code

ST292

114

113845 ✓

14

115589

100

12x

Tuesday, March 29, 2011 8:14:47 AM

Shop Packet Print

Page 2

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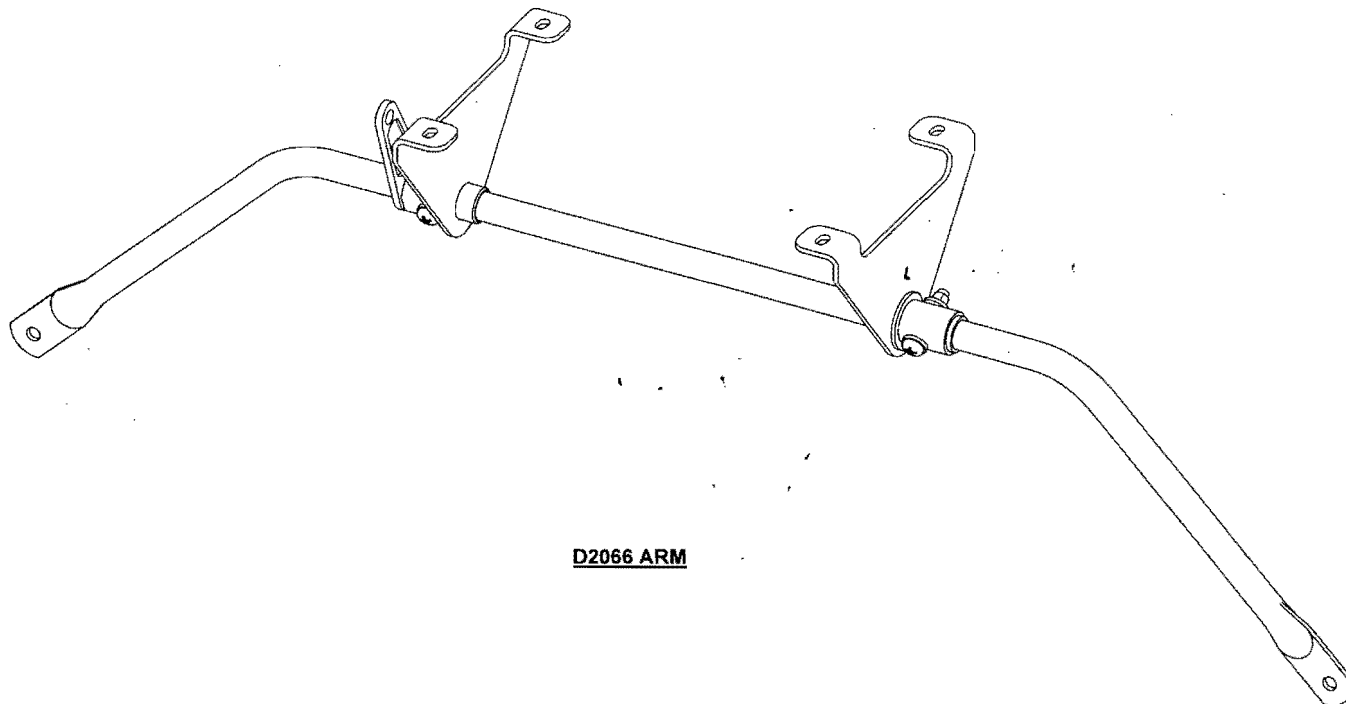
8 7 6 5 4 3 2 1

D

C

B

A



D2066 ARM

#67644

RELEASED
08.07.12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2066" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.85 lbs

C	REDRAWN IN SOLIDWORKS; ADD D2066-1F CUT LENGTH DETAIL (ZN B4-2) AND D2066-1 BENDING DETAIL (ZN C4-2) FOR D2066; Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2). REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.12
B	RE-DESIGNED	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	BW	DRAWING NO	REV. C
MFG. APPR.	BW	D2066	SHEET 1 OF 2
APPROVED	BW	TITLE	SCALE
DE APPR.	BW	ARM	NTS
DATE	08.06.12	COPYRIGHT © 1996 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

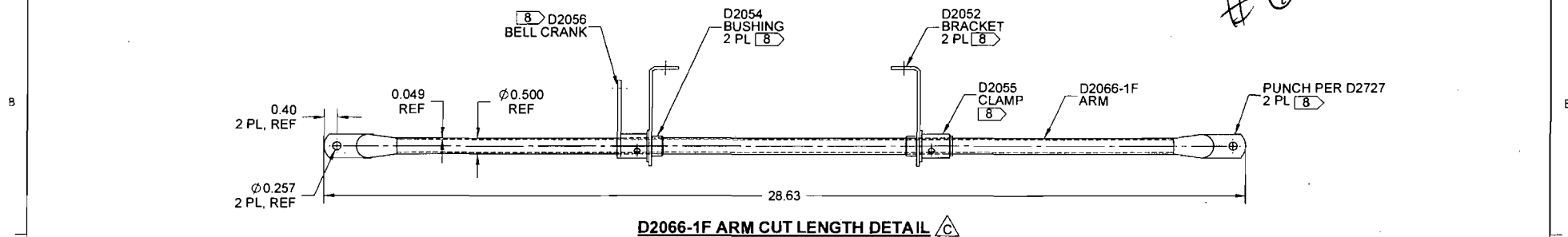
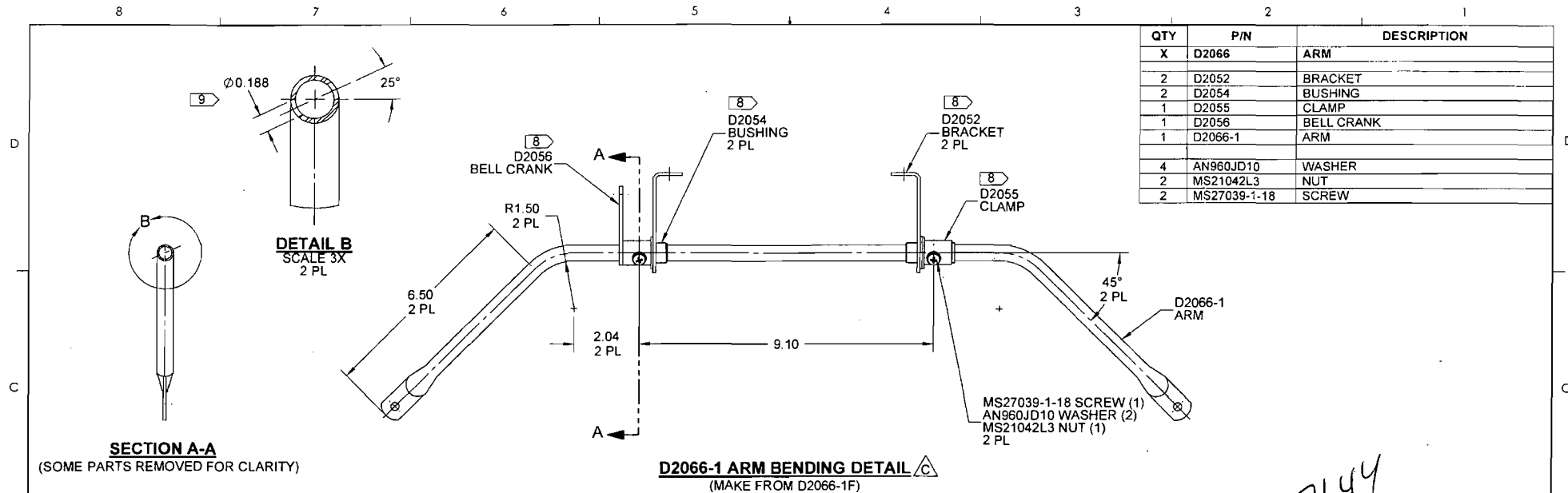
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NOTES:

- 1) MATERIAL: D2066-1F: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2066-1 = 0.62 lbs (SEE SHEET 1 FOR ASSEMBLY WEIGHT)
- 8) BEFORE BENDING: ADD D2052 BRACKETS, D2054 BUSHINGS, D2055 CLAMP AND D2056 BELL CRANK TO D2066-1 ARM
AFTER FIRST END OF D2066-1 IS PUNCHED AND BEFORE SECOND END OF D2066-1 IS PUNCHED
- 9) DRILL $\phi 0.188$ AFTER BENDING

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AL		
CHECKED	JS	DRAWING NO. D2066	REV. C
MFG APPR.	JS	SHEET 2 OF 2	
APPROVED	JS	TITLE ARM	SCALE
DE APPR.	JS	NTS	
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